

Work Order ID 56973

March 16, 2010 9:19:53 AM



Page 1

Item ID: D407-667-105TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 16/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 24/03/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: 

Date: 10-3-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| D407-667-145 | Rev C |

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio
FA249□2-Turn first side as per Folio FA249□3- File transition lines smooth.

Q.M. 10 - 03 - 29①

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

Q.M. 10 - 03 - 29①

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA249□2- File transition lines smooth.□3-
Remove sand and plugs□4-Scribe part # and batch # using vibrating stylus as
per Dwg D206-667-145 □Inside of Cuff(Do not engrave on outside of tube)

Q.M. 10 - 03 - 29①

✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

Q.A. 10-03-29

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

1 - - AWM 10-3-31

150



HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

Memo

0.00

1 - - AWM 10-3-31

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Page 3

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Required Date: 24/03/2010 Req'd Qty: 1.00



Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

M 10/3/31

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in Kanban rack Location: X-TUBE CELL

1

- - AWM 10-3-31

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06 HJ

R/ 10-4-5

(1)

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NOTE: Date & initial all entries

Picklist Print

March 16, 2010 9:19:58 AM

Page 1

Work Order ID: 56973

Parent Item: D407-667-105TRN

Parent Item Name: Crosstube Turning Detail

Comments: IPP Rev:at 08.02.28 new issue EC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Start Date: 16/03/2010

Required Date: 24/03/2010

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D6010-115 | | Manufactured | No | | | 110 | Each | 51.0000 | 1.0000 | | | |



Crosstube Material



MB 20-03-25

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
| Main Warehouse | | |
| LG | 51 | |
| 26424 | 4 | |
| 32308 | 6 | |
| 38343 | 41 | |

LS

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 56473 |
| Description: Crosstube Assembly | Part Number: | D407-667-145 |
| Inspection Dwg: D407-667-145 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.242 | / | | | |
| | 1.865 | +0.005/-0.000 | 1.869 | / | | | |
| | 1.878 | +0.005/-0.000 | 1.882 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.974 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.033 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.168 | / | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | 0.125 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | R0.500 | +/-0.010 | R0.500 | / | | | |
| SIDE B | R0.063 | +/-0.010 | R0.063 | / | | | |
| | 4.438 | +/-0.010 | 4.438 | / | | | |
| | | | | | | | |
| | 2.240 | +0.005/-0.000 | 2.243 | / | | | |
| | 1.865 | +0.005/-0.000 | 1.869 | / | | | |
| | 1.878 | +0.005/-0.000 | 1.882 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.974 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.033 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.168 | / | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | 0.125 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | R0.500 | +/-0.010 | R0.500 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | 4.438 | +/-0.010 | 4.438 | / | | | |
| | 113.20 | +/-0.020 | 113.200 | / | | | |

| | | | | | |
|---------------------|----------|--------------------|---------|----------------------------|-----|
| Measured by: | a.n | Audited by: | AWM | Prototype Approval: | N/A |
| Date: | 10.03.29 | Date: | 10-3-31 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.04.21 | New Issue (P/O D407-667-105) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 09.06.11 | Dwg Rev updated | KJ | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| Item | Qty -145 | Part Number | Description |
|------|-------------|-------------------|--|
| 1 | X | D407-667-145 | CROSSTUBE ASSEMBLY (407 HIGH FWD) |
| 2 | 1 | D6010-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56973

BS10-3-16

RELEASED
08/11/06

| | | | |
|------------|---|---|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 02.05.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>RF</i> | DART AEROSPACE LTD | |
| DRAWN | <i>RF</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>RF</i> | D407-667-145 | SHEET 1 OF 4 |
| APPROVED | <i>RF</i> | TITLE | SCALE |
| DE APPR. | <i>RF</i> | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMING HEREIN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

Dart Aerospace Ltd

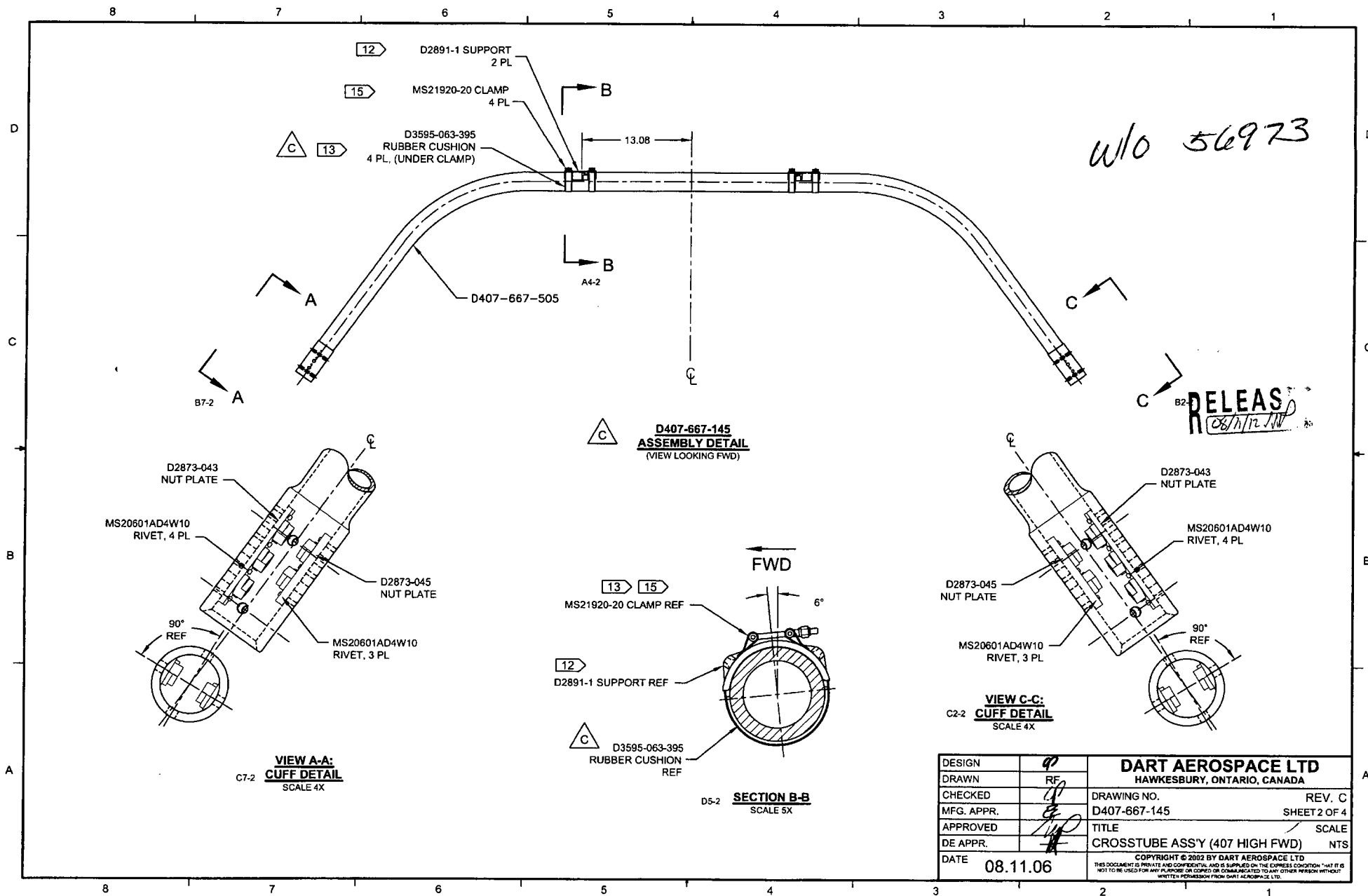
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NOTE: Date & initial all entries



Dart Aerospace Ltd

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NOTE: Date & initial all entries

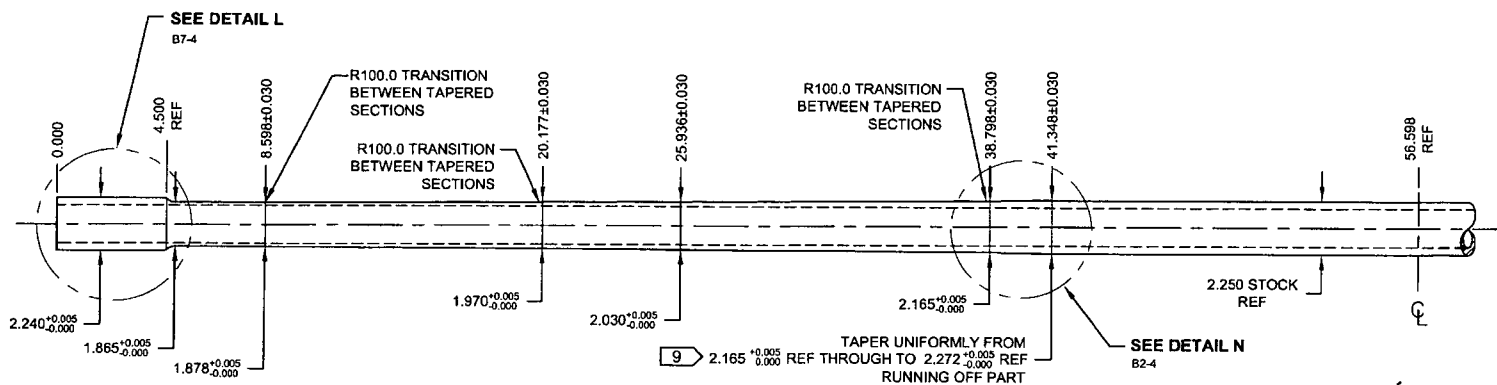
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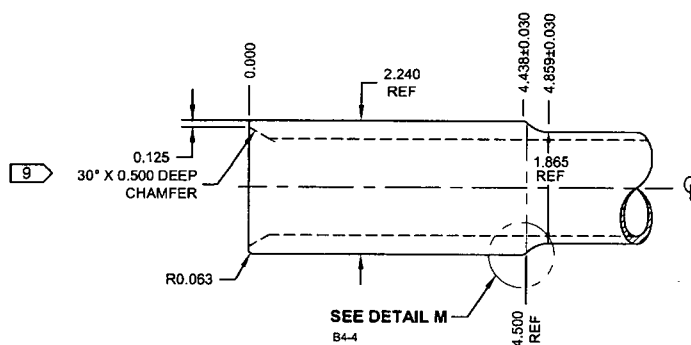
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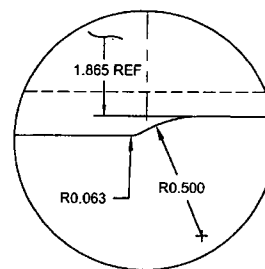


W/O 56973

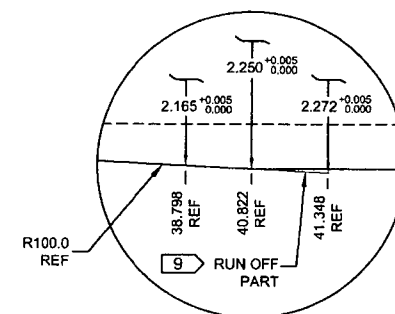
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED

| | | | |
|--|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D407-667-145 | SHEET 4 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
| DATE | 08.11.06 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
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